

Work Order ID 56487

February 24, 2010 1:48:45 PM

Page 1

PRELIMINARY ISSUE

Item ID: D3281-302 **LOB**

Accept

Revision ID:

Item Name: Floor Protector, Aft LH

Start Date: 2/24/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3281

DEO E-1

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 and Folio FTA 009 Dwg. Rev.

Pneum. Folio Rev. *B*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00


Quality Control

SL 10/02/24 x2.

*DAY @ TIME IN 4:10 PM SL
255F. TIME OUT 6:30 AM SL
10/02/25 (X2)*

*Temp @ 335 F
Mould @ 230 F
Release @ 260 F
SL 10/02/24 (X2)*

SL 10/02/24 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.02.25	130	ENGRAVE PIN "D3281-3L06"	Sh.	10/09/25		 10.02.25 451 642	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56487

February 24, 2010 1:48:45 PM

Page 2

Item ID: D3281-3CL

Revision ID:

Item Name: Floor Protector, Aft LH

Start Date: 2/24/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

0.00

0.00

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



QC APPROVAL

2

BB
10/02/25
X2

BB
10/02/25
X2

100226

Work Order ID 56487

February 24, 2010 1:48:46 PM



Page 3

Item ID: D3281-3CL

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft LH

Start Date: 2/24/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

W/056514

10-2-26

(2x)

SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

u 10.02.26

10/02/26

POSITIVE RECALL

EFFECTIVE

10.02.24

AUTH

1

RELEASED

2/10

DATE

10.02.26

Picklist Print

February 24, 2010 1:48:44 PM

Page 1

Work Order ID: 56487

Parent Item: D3281-3CL

Parent Item Name: Floor Protector, Aft LH

Comments: IPP Rev. A 10.02.24 New Issue LL

Start Date: 2/24/10

Required Date: 2/25/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No				sf	2,818.330	8.6666			



Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2818.33

111588

98.33

113127

2720

9.8 sq ft

Wh. 10/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Aft LH		Part Number:	D3281-3
Inspection Dwg: D3281	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Sh. **Date:** 10/02/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75"	✓			
17.1	+/-0.100	17.0"	✓			
14.3	+/-0.100	14.25"	✓			
0.95	+/-0.030	0.961	✓			
0.25	+/-0.030	N/A				
3.1	+/-0.100	N/A				
0.050	Min	0.065	✓			
0.070	Min	0.078	✓			

Measured by: Sh. **Date:** 10/02/25

Audited by: Sh. **Date:** 10/02/25

Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>h</i>	MFG. APPR.	APPROVED		DE APPR.		
DATE 10.02.24	DATE 10.02.24	DATE	DATE		DATE		

PURPOSE

ADD "D3281-xKCL" MATERIAL OPTION.

CHANGE

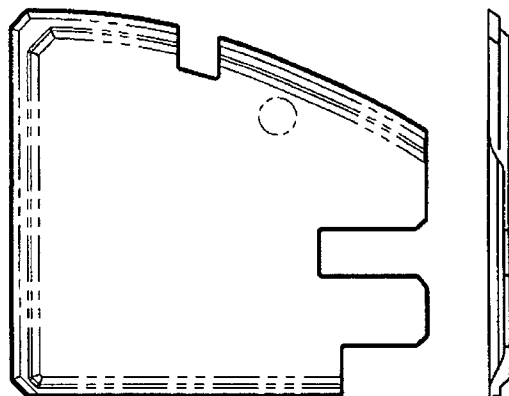
D3281-xKCL PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS, HOWEVER THE MATERIAL AND IDENTIFICATION NOTES ARE AMENDED AS FOLLOWS:

2) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR
(MLEXS.118-90318-08)

7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xKCL" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
LOCATE ENGRAVING ALONG PERIMETER OF PART.

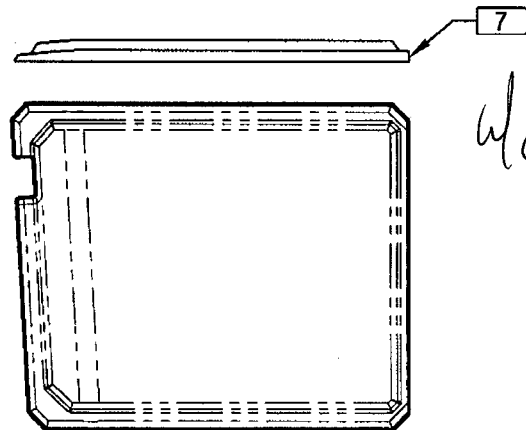
PRELIMINARY ISSUE

q 10.02.24



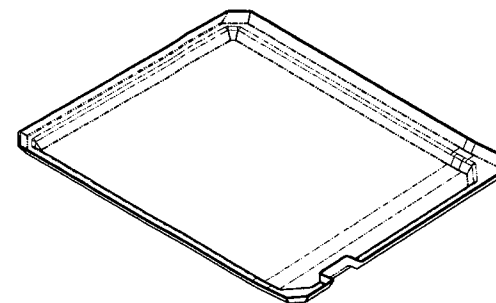
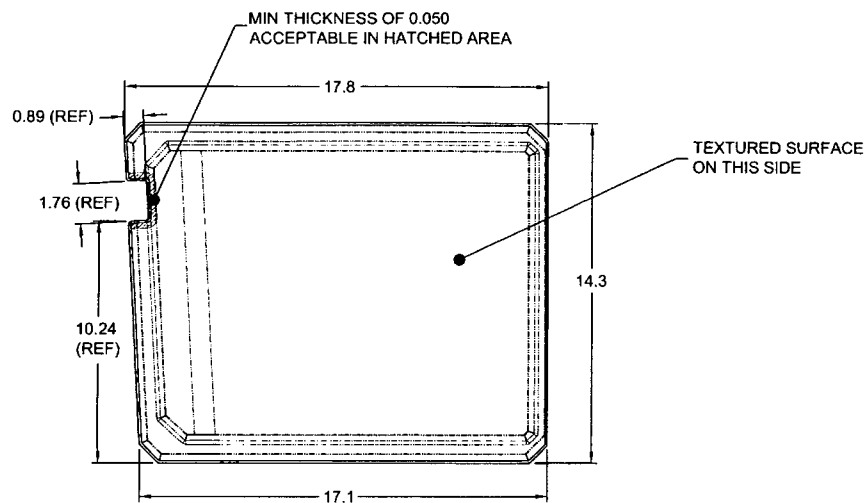
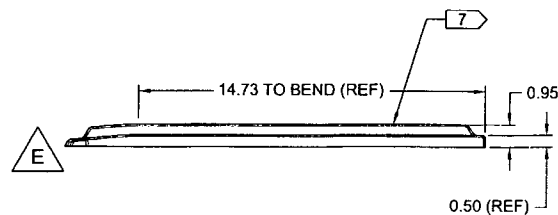
D3281-1KCL FLOOR PROTECTOR (SHOWN)
D3281-2KCL FLOOR PROTECTOR (OPPOSITE)

LOCATION OF ENGRAVING



D3281-3KCL FLOOR PROTECTOR (SHOWN)
D3281-4KCL FLOOR PROTECTOR (OPPOSITE)

LOCATION OF ENGRAVING



WLO
56487

D3281-3 FLOOR PROTECTOR

RELEASED
2010-02-03
MP

D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3281	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	10.01.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>KL</i>	MFG. APPR. <i>DL</i>	APPROVED <i>HL</i>	DE APPR. <i>HL</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25	DATE 10.02.25		

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

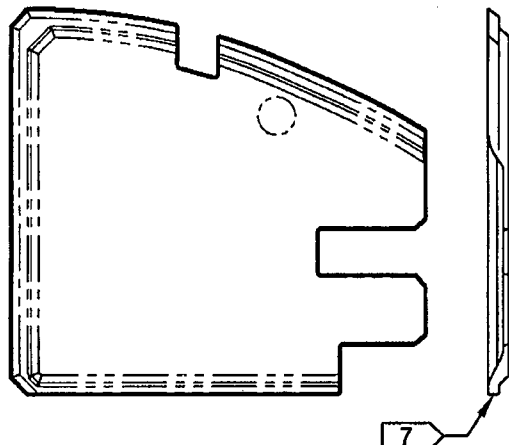
CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

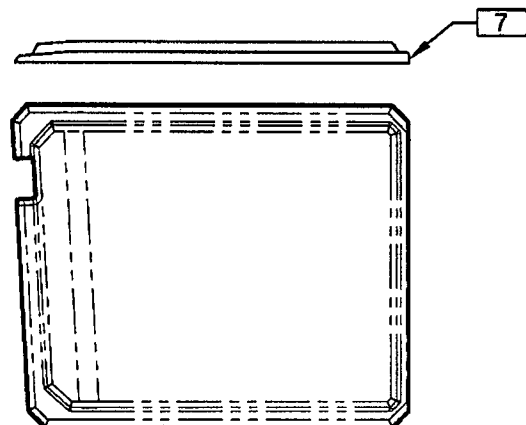
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING



D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING

RELEASED
2010-02-26
MD